

Date: Monday, 3/13/2006 7:29:58 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET
Job Number	: 26209	Part Number	: D28572 -1 see NCR on back
Estimate Number	: 10347	Drawing Number	: D2857 REV A1
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 3/13/2006 S.O. No. : N/A	Drawing Revision	: A1
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : MACHINED PARTS	Due Date	: 3/30/2006
Previous Run	: 26034	Qty:	24 Um: Each
Written By	: SEE COMMENT BELOW		
Checked & Approved By	: J.L. 06.03.13		
Comment	: Est C 00.06.22 Removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"
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Comment: Qty.: 0.4594 f(s)/Unit Total: 11.0250 f(s)
 Material: 2.00" X 1.25"
 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)
 (M6061T6B200001250)
 Batch M18818

(26)

J.L. 06.03.20

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 5.2"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2857-1

J.L. SA 06.03.21

(26)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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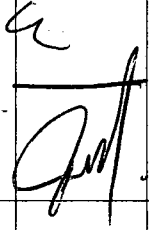
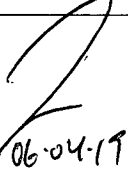

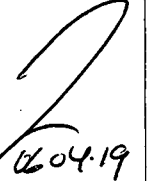
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L. SA 06.03.21

(26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-04-18	3	Parts were made -1, on A-2 order. due to step 3 which calls up folio 02857-1. W/O error.		Change W/O to A-2 folio, to match the part #. W/O to be A-1 and ident-ify parts in stock		 06-04-19	 06-04-19	 06-04-19

NOTE: Date & initial all entries

Date: Monday, 3/13/2006 7:29:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 26209

Part Number: D28572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

SA 06.03.30 (26)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

M DV 06/03/24 (26)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FL 06.03.24 (26)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

M DC 06/03/27 (26)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M 06.03.27 (26)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 165

PV 4/3/29 (26)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

26 06/04/21

Job Completion



U 06.04.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 26209
Description: Hinge Bracket		Part Number: D2857-2
Inspection Dwg: D2857	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.302	✓			
0.340	+/-0.010	.340	✓			
1.110	+/-0.005	1.110	✓			
1.790	+/-0.010	1.791	✓			
1.320	+/-0.005	1.320	✓			
2.000	+/-0.010	1.999	✓			
Ø0.171	+0.005/-0.000	.173	✓			
0.547 0.147	+/-0.010	.0447	✓			
0.376	+/-0.010	.376	✓			
0.126	+/-0.010	.126	✓			
0.611	+/-0.010	.608	✓			
0.063	+/-0.010	.065	✓			
Ø0.166	+0.005/-0.000	.168	✓			
0.911	+/-0.010	.9175	✓			
0.600	+/-0.010	.606	✓			
0.125	+/-0.010	.130	✓			
0.150	+/-0.010	.155	✓			

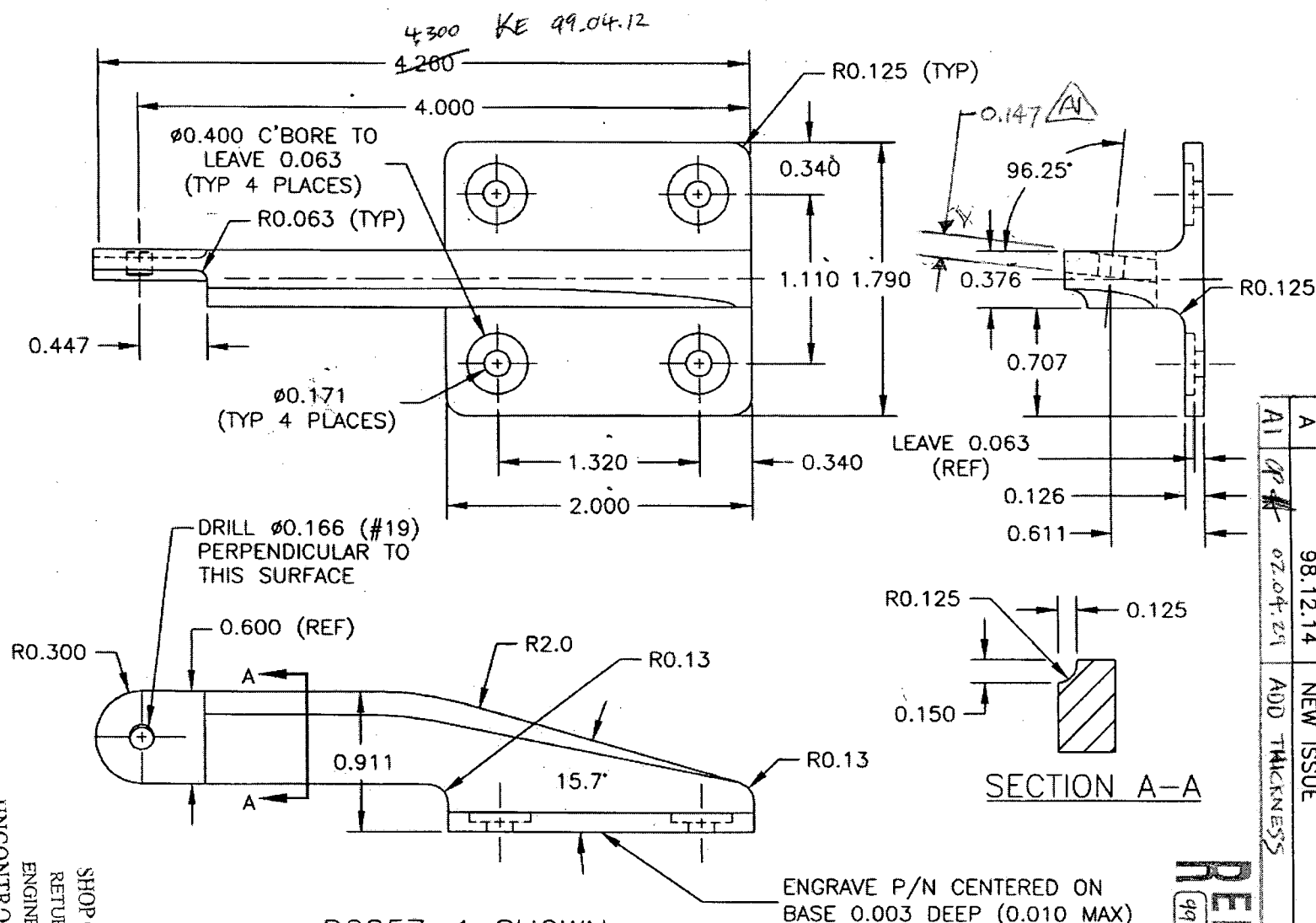
Measured by: J.L. / S.A.	Audited by: BG	Prototype Approval:	N/A
Date: 06.03.	Date: 06.03.21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMESBURY, ONTARIO, CANADA	REV. A
CHECKED KE	APPROVED SP	DRAWING NO. D2857	SHEET 1 OF 1
DATE 98.12.14	TITLE HINGE BRACKET	SCALE 1:1	
A	98.12.14	NEW ISSUE	
A1	99.04.24	ADD THICKNESS	

RELEASED
99.01.06 KE



D2857-1 SHOWN
D2857-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED